

Date: Thursday, 2/23/2006 10:23:56 AM
 User: Kim Johnston

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 25920-1					
Estimate Number	: 10334					
P.O. Number	: N/A			Part Number	: D2804042	
This Issue	: 2/23/2006 S.O. No. : N/A			Drawing Number	: D2804 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 23627			Material	: N/A	
Written By	: SEE COMMENT BELOW			Due Date	: 3/22/2006	
Checked & Approved By	: JF 06.02.23			Qty:	8	
Comment	: Est F 05/03/30 MS21043-3 was MS21042L3			Um:	Each	
KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28042	STA 155 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 155 Bracket Pick: Qty Part Number Description Batch 1 D2804-2 Bracket B25714 (8)	
2.0	D28052	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Stop Pick: Qty Part Number Description Batch 1 D2805-2 Stop B21306 (8) SAD 06:03:01 8	
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing B22549	
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2804	SAD 06103102:01 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:56 AM
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Drawing Name: BRACKET ASSEMBLY

Job Number: 25920

Part Number: D2804042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5

INSPECT WORK TO CURRENT STEP



26-03-02

Comment: INSPECT WORK TO CURRENT STEP

6.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m. 06-03-06

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mt 06-03-06 (8)

8.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	<i>17944</i>
			<i>117078</i>

9.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	<i>M19099</i>

10.0 NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch	
				4 NAS1515H3

Washer M17994

A/R

LPS-3

Corrosion Spray

M17045

SP 06/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-02	8	Press Fit D2809 bushing before Ass'y. ASR Rev D 2804 permanent change made	JM	06-03-02		JM	06-03-02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/03/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:56 AM
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Drawing Name: BRACKET ASSEMBLY

Job Number: 25920

Part Number: D2804042

Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.		SB 06/03/07
12.0	QC5	INSPECT WORK TO CURRENT STEP
		Job 03-07
Comment: INSPECT WORK TO CURRENT STEP		
13.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST156</u>		P 06/03/08 (8)
14.0	DC	DOCUMENT CONTROL
		(8)
Comment: DOCUMENT CONTROL Inspection Level 21		DD 06/03/08

Job Completion



U 06-03-08

D 101 WAS15151B WASHER X4 W17994

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

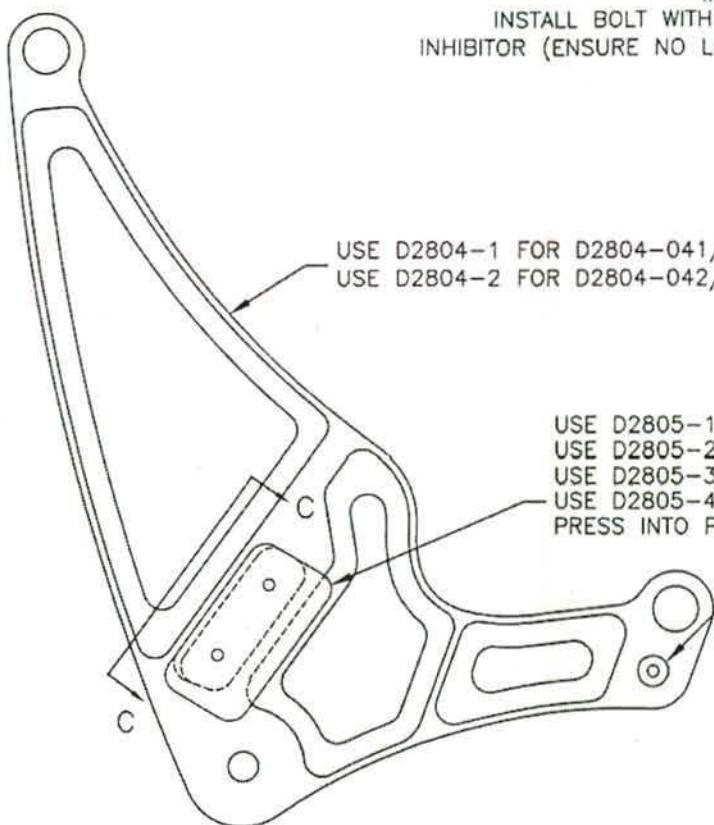
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

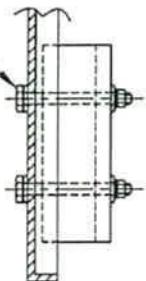
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



M17944
AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

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WITHOUT NOTICE
WORK ORDER
NO. 25920

D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

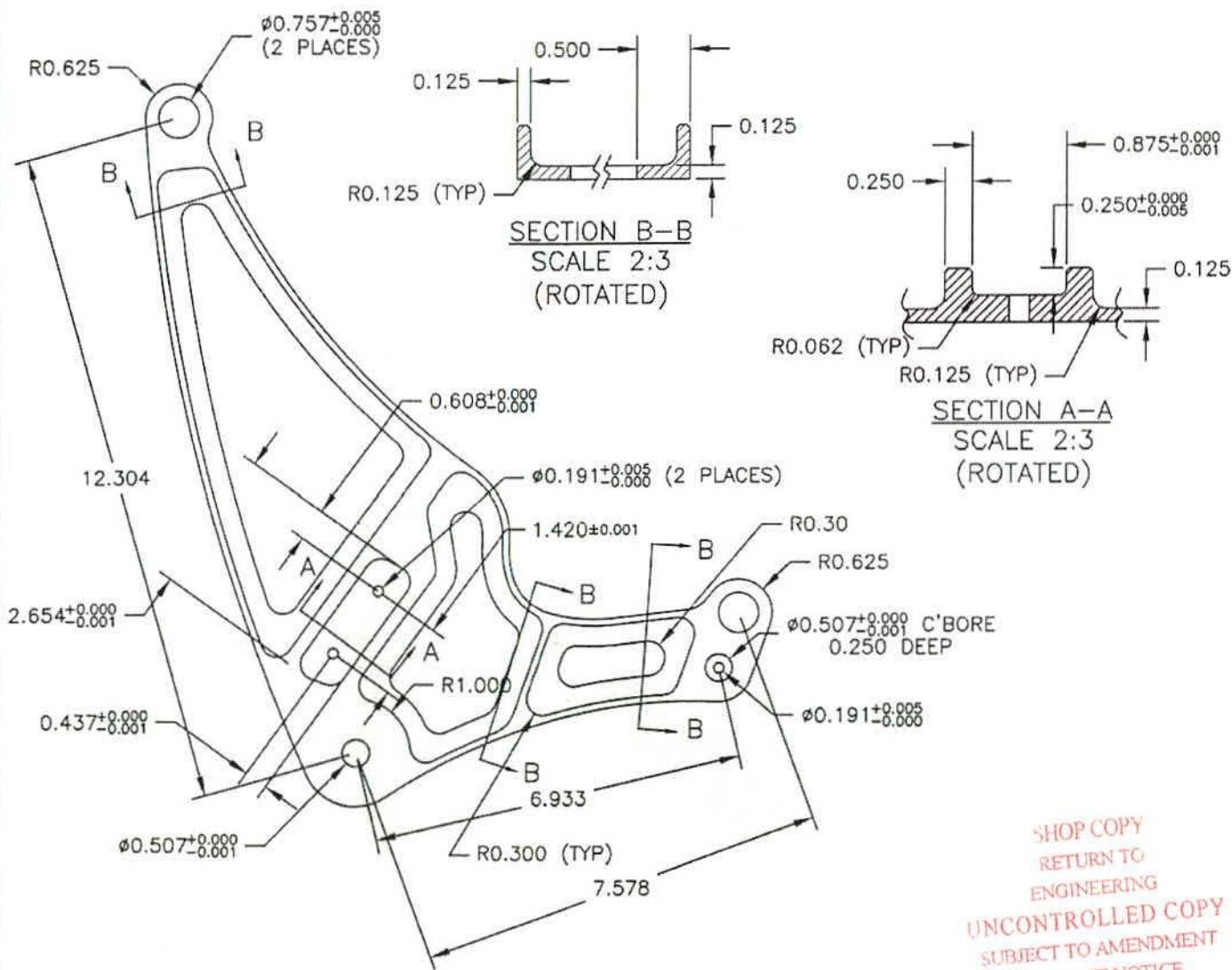
DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804
DATE 04.11.22		REV. B SHEET 1 OF 2
		TITLE STA 155 BRACKET SCALE 1:3

RELEASED

05.03.11 *[Signature]*

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044



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NO. *25920*

D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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